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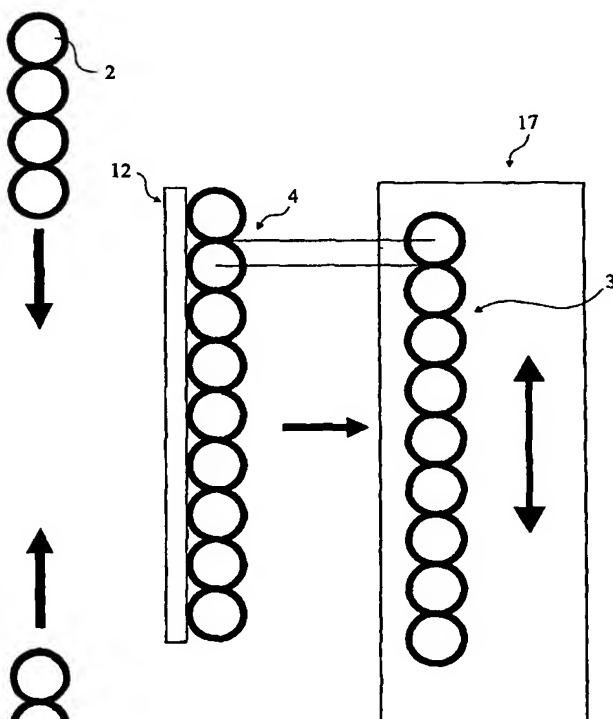
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(54) Title: METHOD AND A MACHINE FOR MAKING A CELL STRUCTURE



(57) Abstract: The invention relates to a method for making a cellular structure (1) comprising a plurality of elements (2), in which method a first plurality of elements (2) is provided that form a first row (3) of elements, and that furthermore a second plurality of elements (2) is provided that form a second row (4) of elements (2). The second row (4) is parallel to the first row (3) but displaced in phase in relation to this. An adhesive is applied to the elements (2) in at least one of the two rows (3, 4) and at least one of the two rows (3, 4) is brought closer to the other, so that the two rows are brought together and thereby bonded to one another by the adhesive. The invention also relates to a machine for executing the method according to the invention.

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METHOD AND MACHINE FOR MAKING A CELL STRUCTURE

TECHNICAL FIELD

The present invention relates to a method and a machine for making a cell structure comprising a plurality of elements. The elements forming part of the cell structure can consist of short tube pieces glued fixedly to one another. A cell structure of this kind can be used for example as part of a sandwich construction in building elements and in this case promotes strength in combination with low weight.

10 PRIOR ART

A cell structure composed of a plurality of tubular elements is known previously from US patent 2,477,852, for example. The tubular elements are stated to be able to have a length from around $\frac{1}{4}$ inch to 2 inches (6.4 mm to 51 mm) and a diameter from $\frac{1}{4}$ inch to 2 inches (6.4 mm to 51 mm). The tubular elements or tube pieces are stated to be able to be joined to one another by applying adhesive, for example.

OBJECT OF THE INVENTION

The object of the invention is to provide a method and a machine for making a cell structure from a plurality of elements. Another object of the invention is to provide a method and a machine for making a cell structure that permits automatic production with a high level of productivity and high operating reliability. A further object of the invention is to provide a machine that can be adapted to the size of the elements forming part of the cell structure.

25 DESCRIPTION OF THE INVENTION

The method according to the invention relates to production of a cellular structure comprising a plurality of elements. The cell structure that is produced by means of the method according to the invention can be used for example as part of a sandwich construction in building elements. According to the inventive method, a first plurality of uniform elements (elements having the same shape) is provided, which form a first row of elements. Furthermore, a second plurality of uniform elements is provided, which also have the same form as the elements in the first plurality and which form a second row of elements. The second row suitably contains as many elements as the first row. The second row is also preferably parallel to the first row, but preferably displaced in phase in relation

to the first row. The term "displaced in phase" is understood here to mean that the second row is displaced by a certain distance in its longitudinal direction in relation to the first row, which distance is less than the extension of one of the uniform elements in the longitudinal direction of the two rows. An adhesive is applied to the elements in at least one of the two rows and at least one of the two rows is brought closer to the other, so that the two rows are brought together and thereby bonded to one another by the adhesive. The two rows will then thereby form a composite cell structure, which is then located in a first position. To add to the cell structure, a third plurality of elements is then provided, which form a third row of elements. The third row of elements is suitably parallel to the rows in the composite cellular structure. The cell structure already existing is moved a certain distance in the longitudinal direction of the first and second row of elements, so that the cellular structure is moved from the first position to a second position. An adhesive is applied to elements in at least one of the second row and the third row. The adhesive can be applied in this case either before, after or at the same time as the cellular structure is moved to the second position. The third row and the cell structure can then be brought together with one another so that they are thereby bonded to one another by the adhesive. The third row thereby becomes part of the cellular structure.

In the method according to the invention, it is the case that the second plurality of elements is best supplied in that elements intended to form the second plurality of elements are fed in a direction parallel to the first row of elements until a predetermined number of elements that form a second row parallel to the first is located in a predetermined position, so that the second row is complete. Bringing the elements in at least one of the two rows closer to the other then takes place after the second row has attained its predetermined position.

According to a particularly advantageous variant of the invention, the second plurality of elements is provided in that elements intended to form the second plurality of elements are fed from two opposing directions. The two opposing directions are both parallel to the first row of elements and elements are transported until the elements fed in one direction meet elements transported in the opposing direction, and together with the elements transported from the other direction form a second row of elements. Feeding from each direction can also be interrupted after a predetermined number of elements has been transported. Of course, it is the case with all embodiments that the feed can be interrupted after a

predetermined number of elements has been transported. Bringing at least one of the two rows closer to the other takes place finally after the second row has been formed.

5 Interrupting the feed after a predetermined number of elements has been transported can be achieved in the following manner, for example. During feeding of the preferably circular-cylindrical elements, elements are allowed in both feed directions to pass a detector linked to a control unit/logic unit. The logic unit senses how many circular-cylindrical elements pass the detector and after a predetermined number of elements has passed, the control unit/logic unit emits a signal that the feed is to be interrupted.

10

It is preferably the case that all elements have the same shape and have a circular-cylindrical shape, so that the composite cell structure formed will consist of a plurality of cylinders that are joined together, preferably glued.

15 Bringing together of the elements in the first and second row of elements preferably takes place in that the elements in the second row are conveyed at the same time towards the first row, so that the whole of the second row is conveyed towards the first row as a coherent unit.

20 When adhesive is applied to the elements in a row, this can best be carried out as follows. The adhesive is applied to the elements in that a carriage provided with at least one sensor and a nozzle connected to a source of adhesive is guided along the row at a predetermined speed. The sensor is placed at a distance from the nozzle and detects the presence or absence of an element. The sensor emits a signal to a logic unit when the presence of an
25 element is detected and the logic unit can then calculate, starting out from the known speed and the distance between the nozzle and the carriage's sensor, the time that remains until the nozzle is located in a certain position in relation to an element detected by the sensor. The logic unit can then emit a pulse to activate the nozzle when the time calculated has elapsed, so that adhesive is dispensed towards the preferably circular-cylindrical element
30 when the nozzle passes it. Furthermore, it can thereby be ensured that adhesive is applied to the correct part of the element.

The invention also relates to a machine for making a cell structure comprising a plurality of elements. The machine according to the invention comprises a guide with inner walls that

are preferably straight and form a channel in which a plurality of uniform elements can be fed forwards. The channel can best be arranged to be fed from two different directions.

Furthermore, the machine comprises one or more drives/driving devices disposed to act on
5 elements placed in the channel to convey these in a first direction, so that a coherent row of
elements can be conveyed forwards in the channel. A carrier is arranged in connection with
the channel and the carrier has an extension that is principally parallel to the first direction.
The carrier is also movable in a second direction principally perpendicular to the first
10 direction, so that the carrier can move in the second direction and in doing so take with it a
coherent row of elements that have been transported in the channel, so that the row is
transported to an end position for the movement of the carrier in the second direction. In an
advantageous embodiment, the guide comprises two fixed parts and a movable part, the
movable part of the guide being arranged so that it can move in the vertical direction
15 together with the carrier from a first position, in which the movable guide part is located in
a plane separate from the working surface of the table, to a second position in which at least
part of the movable guide part is located on a level with the working surface of the table.
The movable guide part comprises a support on which elements for the cellular structure
can be placed, which support forms a floor in the channel, and the support can be adjusted
20 in the vertical direction so that elements of different height can be placed in the correct
position in relation to the carrier. The machine is provided with at least one nozzle that is
connected to a source of adhesive. The nozzle is disposed to be movable in a direction
parallel to the first direction and is either disposed to apply adhesive to a row of elements
that have just been conveyed to the end position, or to apply adhesive to a row of elements
25 before these have begun to be conveyed towards the end position by the carrier. The nozzle
can thus move along a coherent group of elements and apply adhesive to these.

In an advantageous embodiment of the invention, at least one sensor disposed to detect the
elements transported in the channel is located in connection with the channel. The sensor is
suitably linked to the driving device in this case – for example via a logic unit – so that it is
30 possible to interrupt the transportation of elements when a predetermined number of
elements has passed the sensor.

The machine according to the invention suitably comprises a table for receiving a coherent
row of elements, which table has a flat working surface on which the elements received can

slide. The carrier is arranged in this case in such a way in relation to the table that the movement of the carrier up to the end position for its movement in the second direction can carry elements from the channel to the table for delivery onto the working surface of the table. In a preferred embodiment, the table is movable in a direction perpendicular to the direction of movement of the carrier and parallel to the first direction.

A plate or beam is suitably arranged in connection with the table, which plate or beam is movable in a direction to and from the working surface of the table. It is thereby possible to correct any positional errors of the individual elements after two rows have been brought together.

The machine is preferably provided with a stand on which a carriage is arranged movably in connection with the working surface of the table. On the carriage, the nozzle is arranged so that on movement of the carriage, the nozzle can be guided along a row of elements standing on the working surface of the table. The carriage is provided in this case with at least one sensor that can detect the presence of an element placed on the table. The sensor is placed at a distance from the nozzle in the direction of movement of the carriage. The carriage preferably has two sensors. The carriage can be driven at a predetermined speed and the machine comprises a logic unit that knows the predetermined speed and the distance between the sensor and the nozzle of the carriage. The logic unit is also connected to the carriage's sensor, so that while the carriage is moving the logic unit can calculate the time remaining before the nozzle is located in a certain position in relation to an element detected by the sensor.

DESCRIPTION OF DRAWINGS

Fig. 1 shows, in perspective, a cell structure produced according to the method according to the invention.

Fig. 2 shows diagrammatically and seen from above a cell structure produced according to the method according to the invention.

Fig. 3 shows, in perspective, a building element containing a cell structure produced according to the method according to the invention.

Fig. 4 shows diagrammatically, seen from above, the bringing together of two rows of circular-cylindrical elements during simultaneous transportation of a further row.

Fig. 5 shows diagrammatically, seen from above, a further step in the production process.

Fig. 6 shows diagrammatically, seen from above, yet another step in the production process.

Figs. 7 – 11 show diagrammatically and from a lateral perspective steps in the production process corresponding to the steps shown in Figs. 4 – 6.

5 Fig. 12 shows how adhesive can be applied to a row of elements.

Fig. 13 shows in greater detail a part of the finished cell structure in which the joining points have been marked.

Fig. 14 shows in perspective how circular-cylindrical elements are fed from one end of a machine according to the invention.

10 Fig. 15 shows in perspective another part of the machine according to the invention.

Fig. 16 shows on a larger scale part of what is also shown in Fig. 15.

Fig. 17 shows diagrammatically seen from above feeding of the circular-cylindrical elements from one end of the machine.

Fig. 18 shows diagrammatically how the feeding of elements can be controlled.

15 Fig. 19 shows a part of the feed channel in perspective.

Fig. 20 shows diagrammatically and seen from above a part of the feed channel.

Fig. 21 shows diagrammatically the control of the nozzle for applying adhesive.

Figs. 22-24 show in perspective how the position of the elements can be corrected.

Figs. 25a and b show height adjustment for elements of varying height.

20

DETAILED DESCRIPTION OF THE INVENTION

Fig. 1 shows a composite cell structure 1, which is composed of a plurality of circular-cylindrical tube parts 2. Fig. 2 shows a cell structure of this kind seen from above. Such a cell structure can be used for example as part of a sandwich construction in building elements. A building element that contains such a cell structure can be obtained by gluing boards, for example particle boards, to opposing sides of the cell structure. An example of such a building element is shown in Fig. 3, in which a cell structure 1 forms a layer in a building element 23 that has been formed by gluing particle boards 24, for example, firmly to opposing sides of the cell structure 1.

30

The invention shall now be explained with reference to Figs. 4 – 6. According to the method according to the invention, a first plurality of uniform elements 2 (elements that have the same shape) is provided, which form a first row 3 of elements. A second plurality of uniform elements 2 is also provided, which also have the same shape as the elements 2 in

the first plurality and which form a second row 4 of elements. The second row 4 suitably contains as many elements as the first row 3. The second row 4 is also preferably parallel to the first row 3, but preferably displaced in phase relative to the first row. The term "displaced in phase" is understood here to mean that the second row 4 is displaced by a certain distance in its longitudinal direction in relation to the first row 3, which distance is less than the extension of one of the uniform elements 2 in the longitudinal direction of the two rows 3, 4. An adhesive is applied to the elements 2 in at least one of the two rows 3, 4 and at least one of the two rows 3, 4 is brought closer to the other so that the two rows 3, 4 are brought together and thereby bonded to one another by the adhesive. The two rows 3, 4 will then thereby form a composite cell structure 1, which is then located in a first position. To add to the cell structure 1, a third plurality of elements 2 is then provided, which form a third row 5 of elements, which is evident from Fig. 5. The third row 5 of elements 2 is suitably parallel to the rows 3, 4 in the composite cellular structure 1. The cell structure 1 already existing is moved a certain distance in a longitudinal direction of the first 3 and the second row 4 of elements 2 so that the cellular structure 1 is moved from the first position to a second position. An adhesive is applied to the elements 2 in at least one of the second row 4 and the third row 5. The adhesive can be applied in this case either before, after or at the same time as the cellular structure 1 is moved to the second position. The third row 5 and cell structure 1 can then be brought together with one another so that they are thereby bonded to one another by the adhesive. The third row 5 thereby becomes part of the cellular structure 1. The cell structure 1 thus obtained can then be added to by a fourth row as indicated in Fig. 6. It is naturally possible then to add any further number of rows of elements 2 to the cell structure 1.

In the method according to the invention, it is the case that the second plurality of elements 2 is best provided in that elements 2 intended to form the second plurality of elements 2 are fed in a direction parallel to the first row 3 of elements 2 until a predetermined number of elements 2 that form a second row 4 parallel to the first is located in a predetermined position, so that the second row 4 is complete. The bringing of elements in at least one of the two rows 3, 4 closer to the other then takes place after the second row 4 has reached its predetermined position.

According to a particularly advantageous variant of the invention, the second plurality of elements is provided in that elements intended to form the second plurality of elements are

fed from two opposing directions. Fig. 4 and Fig. 6 show that the feed can be undertaken from two opposing directions. Fig. 4 shows for example how a third row 5 of elements 2 is built up while the second row 4 is being brought closer to the first row 3. It is perceived that all rows can be built up in the same way. The two opposing directions are both parallel to the first row 3 of elements and the elements are transported until the elements 2 that are fed in one direction meet elements 2 that have been transported in the opposite direction and together with the elements transported from the other direction form a second row 4 of elements 2. The feed from each direction can also be interrupted after a predetermined number of elements has been transported. It is naturally the case with all embodiments that the feed can be interrupted after a predetermined number of elements has been transported. The bringing of at least one of the two rows 3, 4 closer to the other takes place finally after the second row 4 has been formed.

The interruption of the feed after a predetermined number of elements 2 has been transported can be achieved in the following way, for example. During feeding of the preferably circular-cylindrical elements 2, elements are allowed in both feed directions to pass a detector 6 linked to a control unit/logic unit 7. The logic unit 7, which can consist of a computer 7, senses how many circular-cylindrical elements 2 pass the detector 6 and after a predetermined number of elements 2 has passed, the control unit/logic unit 7 emits a signal that the feed is to be interrupted.

It is preferably the case that all elements 2 are uniform (have the same shape) and that they have a circular-cylindrical shape, so that the composite cell structure 1 formed will consist of a plurality of joined – preferably glued – cylinders. The cylinders 2 can suitably consist of tube pieces 2 with a height of 5 mm to 200 mm and a diameter from 10 mm to 250 mm. A suitable material for the tube pieces can be a cardboard laminate, for example. Other materials are of course also conceivable, such as plastic, wood or metal.

The bringing together of elements in the first 3 and the second row 4 of elements preferably takes place in that elements in the second row 4 are conveyed simultaneously towards the first row 3, so that the whole of the second row 4 is conveyed towards the first row 3 as a coherent unit.

When applying adhesive to elements in a row, this is best carried out as follows. With reference to Fig. 12a, 12b and Fig. 21 it is shown how the adhesive is applied to elements in that a carriage 15 provided with at least one sensor 16 and a nozzle 13 connected to a source 14 of adhesive is guided along the row at a predetermined speed. The sensor 16 is placed at a distance from the nozzle 13 and detects the presence or absence of an element 2. The sensor 16 emits a signal to a logic unit 7 when the presence of an element 2 is detected and the logic unit 7 can then calculate, starting out from the known speed and the distance between the nozzle 13 and the carriage's sensor 16, the time that remains until the nozzle 13 is located in a certain position in relation to an element detected by the sensor. The logic unit 7 can then emit a pulse to activate the nozzle 13 when the time calculated has elapsed, so that adhesive is dispensed towards the preferably circular-cylindrical element 2 when the nozzle 13 passes this. Furthermore, it can thereby be ensured that adhesive is applied to the correct part of the element 2. As shown in Fig. 12b, the nozzle can be arranged to dispense adhesive towards two points 25 along the circumference of a tube piece 2. These two points 25 then constitute joining points in the cellular structure 1. It is perceived in this case that each circular-cylindrical element or tube piece 2 will have four joining points 25 with surrounding elements 2, as shown in Fig. 13. The cell structure 1 will then be built up of circular-cylindrical elements or tube pieces 2 that have six points of contact with surrounding tube pieces, of which four contact points also constitute joining points 25, while two contact points do not constitute joining points 25, as no adhesive is applied to these points.

The invention also relates to a machine for producing a cell structure 1 comprising a plurality of elements 2. With reference to Fig. 14-20, it is shown how the machine according to the invention comprises a guide 8 with inner walls 9 that are preferably straight and form a channel 10 in which a plurality of uniform elements 2 can be fed forwards. The channel 10 can suitably be arranged to be fed from two different directions.

In Fig. 15, 18 and Fig. 4 – 6 it is shown that the machine according to the invention can comprise a table 17 for receiving a coherent row of elements, which table 17 has a flat working surface on which received elements 2 can slide. The carrier 12 is arranged in this case in such a way in relation to the table 17 that the movement of the carrier 12 forwards to the end position for its movement in the second direction can convey elements from the channel 10 to the table 17 for delivery onto the working surface of the table 17. In a

preferred embodiment, the table 17 is movable in a direction perpendicular to the direction of movement of the carrier 12 and parallel to the first direction.

5 A plate or beam 18 is suitably arranged in connection with the table 17, which plate or beam 18 is movable in a direction to and from the working surface of the table 17. Any positional errors with regard to individual elements 2 can thereby be corrected after two rows have been brought together. With reference to Figs. 10 and 11 and Figs. 22 – 24, it is shown how the beam 18 is used to correct positional errors. One or more elements 2 have come to protrude above the rest of the cell structure during some part of the transportation.
10 After the carrier 12 has delivered a row of elements 2, the beam 18 therefore moves down to lie against the cell structure 1 and will thereby press down any elements 2 projecting.

The machine also comprises one or more drives/driving devices 11 disposed to act on elements 2 placed in the channel 10 to convey these in a first direction, so that a coherent
15 row of elements 2 can be carried forwards in the channel 10. With reference to Fig. 14 and Fig. 17 it is shown how elements 2 are transported on a conveyor belt 26 towards a guide strip 27 around which a drive belt 28 runs. When the elements 2 reach the guide strip 27 through feeding on the conveyor belt 26, they will be fed by the drive belt 28 towards a guide 8 with rails, the inner walls 9 of which form a channel 10. Both the conveyor belt 26
20 and the drive belt 28 can be driven by a common driving device 11.

As shown in Fig. 15 and Fig. 16 and in Fig. 4 – 6, a carrier 12 is arranged in connection with the channel 10 and the carrier 12 has an extension that is principally parallel to the first direction. The carrier 12 is also movable in a second direction chiefly perpendicular to
25 the first direction, so that the carrier 12 can move in the second direction and thereby take with it a coherent row of elements 2 that have been transported in the channel 10, so that the row is transported to an end position for movement of the carrier 12 in the second direction. In an advantageous embodiment (see Fig. 18, for example) the guide 8 comprises two fixed parts 20 and a movable part 21, the movable part 21 of the guide 8
30 being disposed to be able to move in the vertical direction (see Fig. 7, 8 and 11) together with the carrier 12 from a first position, in which the movable guide part 21 is located in a plane separate from the working surface of the table, to a second position in which at least a part of the movable guide part 21 is located on a level with the working surface of the table 17. The movable guide part 21 comprises a support 22, on which elements for the cellular

structure 1 can be placed, which support 22 forms a floor in the channel 10 and the support 22 can be adjusted in the vertical direction, so that elements of different height can be placed in the correct position in relation to the carrier 12. With reference to Fig. 25a, it is shown diagrammatically how circular-cylindrical elements of a certain height are received in the movable control part 21. With reference to Fig. 25b, it shall now be explained how elements of a lower height are handled. To receive elements 2 of a different height, a spacer 29 is used to lift the support 22 that forms the floor in the channel. It is thereby ensured that the carrier 12 continues to be in the correct position in relation to the elements 2 in the channel, in spite of the fact that the height of the elements 2 is now lower.

10

As shown in Fig. 12, the machine is best provided with at least one nozzle 13 that is connected to a source 14 of adhesive. The nozzle 13 is disposed to be movable in a direction parallel to the first direction and is either arranged to apply adhesive to a row of elements 2 that has just been conveyed to the end position, or to apply adhesive to a row of elements 2 before these have begun to be conveyed towards the end position by the carrier 12. The nozzle 13 can thus move along a coherent group of elements 2 and apply adhesive to these.

In an advantageous embodiment of the invention, at least one sensor 6 is located connected to the channel 10 and disposed to detect the elements transported in the channel 10 as shown in Figs. 18 – 21. The sensor 6 is suitably connected in this case to the driving device 11 – for example via a logic unit 7 – so that the transportation of elements 2 can be interrupted when a predetermined number of elements 2 has passed the sensor 6.

The machine is preferably provided with a stand 19, on which a carriage 15 is arranged movably in connection with the working surface of the table 17, see Fig. 21. The nozzle 13 is arranged on the carriage 15 so that on movement of the carriage 15 the nozzle 13 can be guided along a row of elements 2 standing on the working surface of the table 17. The carriage 15 is provided here with at least one sensor 16 that can detect the presence of an element placed on the table 17. The sensor 16 is placed at a distance from the nozzle 13 in the direction of movement of the carriage. The carriage 15 preferably has two sensors 16. The carriage 15 can be driven at a predetermined speed and the machine includes a logic unit 7 that knows the predetermined speed and the distance between the sensor or sensors 16 and the nozzle 13 of the carriage 15. The logic unit 7 is also connected to the sensor 16

of the carriage 15, so that while the carriage 15 is moving the logic unit 7 can calculate the time remaining before the nozzle 13 is located in a certain position in relation to an element 2 detected by the sensor 16.

5 The machine operates in the following way. When the drive 11 is activated, elements 2 are carried by the conveyor belt 26 towards the drive belt 28, which pushes the elements into the channel 10. Due to the pressure from elements coming from behind, the elements 2 are carried forwards in the channel 10. The elements 2 will thus pass the detector 6, which will emit a signal to the logic unit 7 for each element 2 that passes. When a predetermined
10 number of elements 2 has passed the detector 6, the logic unit 7 will order the drive 11 to stop. Feeding then ceases. The predetermined number of elements 2 is the number required to fill the movable guide part 21. Feeding is thus interrupted when the channel 10 of the movable guide part 21 is full of circular-cylindrical elements or tube pieces 2. The detectors 6 can be located in either the movable guide part 21 or in one of the fixed guide
15 parts 20 or in both the movable guide part 21 and the fixed guide parts 20. If it is elected to place detectors 6 in the movable guide part 21, however, it is not necessary to count passing elements. One or more detectors 6 can be placed instead connected to the centre of the channel 10 of the movable guide part 21. The detector or detectors 6 then detect quite easily that circular-cylindrical elements 2 have reached the centre of the channel 10 from
20 both feed directions. The logic unit 7 that is connected to the detectors 6 can then draw the conclusion that the channel 10 of the movable guide part 21 is completely full and interrupt the feed of new elements 2. It is of course possible to let the logic unit 7 both count the elements 2 that pass a detector 6 and also detect whether the channel 10 of the movable guide part is full.

25 When the channel 10 of the movable guide part 21 is full and feeding has been made to stop, the movable guide part 21 and the carrier 12 are located somewhat below the level of the table 17. By means of lifting devices that are not shown, for example hydraulic or pneumatic cylinders, the guide part 21 is lifted together with the carrier 12 up to a level
30 where the floor of the guide part is on a level with the working surface of the table 17. The actuating device 30 now pushes the carrier 12 in over the working surface of the table 17. A row 4 of circular-cylindrical elements 2 will thereby be conveyed by the carrier 12 in onto the working surface of the table 17. It may now be assumed that a preceding row 3 of circular-cylindrical elements 2 has already been delivered onto the working surface of the

table 17 in a preceding work step. While the new row 4 was being transported, the following happened. The carriage 15 conveyed the nozzle 13 along the row 3, the carriage sensors 16 detecting the presence of elements 2 in the row 3. The nozzle 13 sprayed adhesive at two points on each element 2. In addition, the table 17 was moved a distance in
5 a direction parallel to the feed direction of elements 2 in the channel 10. The table 17 was moved in this case a distance that is half the diameter of one of the circular-cylindrical elements. The row 3 is thereby displaced in phase. In principle, phase displacement can also be obtained by selecting a different distance, but not movement by a distance that constitutes a whole diameter of a circular-cylindrical element or a whole number of
10 cylinder diameters.

The preceding row 3 is then displaced in phase in relation to the next row 4 that is delivered onto the table and the elements 2 in the preceding row 3 have also been provided with adhesive, for example a glue. When the carrier 12 conveys the new row 4 towards the
15 preceding row 3, the new row 4 is conveyed to lie close to the preceding row 3 and is bonded to this by the adhesive that has been applied to the elements 2 in the preceding row 3. The new row 4 will also push the preceding row 3 backwards across the table 17. The new row 4 and the preceding row 3 now form a composite cell structure 1.

20 The carrier 12 will then be retracted at the same time as the beam 18 is made to execute a working stroke downwards and move down to lie close to the cell structure 1. Elements 2 that stick up from the cell structure 1 will then be pressed down into the correct position. The levelling beam 18 then travels up again. During this time the carrier 12 has been retracted to its position in connection with the channel 10. The movable guide part 21 now
25 moves down to the feed position, whereupon a new working cycle can be started. New elements 2 are carried forwards in the channel 10 and the carriage 15 will move along the new row 4 in the cell structure 1 and adhesive will be applied to the elements 2 in the new row 4. Furthermore, the table 17 will again be moved by a certain distance, but in the opposite direction to the preceding movement of the table 17, so that the table 17 returns to
30 its previous position. It is thereby ensured that the newly coated row 4 will be displaced in phase in relation to the next row 5.

A quick and operationally reliable way of producing cell structures is offered by the invention. If feeding from two directions is used, the advantage is obtained that the cycle

times are lower. Due to the fact that the level of the floor of the channel can be adjusted, the advantage is achieved that tube pieces of different height can be used. By using a levelling beam, the advantage is achieved that an incorrect position of elements forming part of the cell structure can be corrected.

5

Due to the fact that the carriage with the nozzle is provided with sensors linked to a logic unit, the advantage is achieved that adhesive can be placed on the elements in the desired position. The consumption of adhesive is also reduced thereby. If the table is arranged movably, the advantage is achieved that all elements in a row can be displaced in phase easily in relation to the next row. If the feed is controlled by a logic unit linked to sensors, the advantage is achieved that the feed can be interrupted automatically. If a whole row is moved towards a preceding row as a coherent unit, the advantage is achieved that the production process is quicker than if elements are moved singly. If detectors are placed in the movable guide part, the advantage is achieved that the feed can be controlled according to whether the channel is full.

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15

As the channel is not locked at the same height as the table, but can be raised and lowered, space is provided for the nozzle.

20

CLAIMS

1. Method for making a cellular structure (1) comprising a plurality of elements (2), which method comprises the following steps:
 - a) providing a first plurality of uniform elements (2), which form a first row (3) of
5 elements;
 - b) providing a second plurality of uniform elements (2), which also have the same shape as the elements (2) in the first plurality and which form a second row (4) of elements (2), the second row (4) containing as many elements (2) as the first row (3) and being
10 parallel to the first row (3) but displaced by a certain distance in its longitudinal direction in relation to the first row (3), which distance is less than the extension of one of the uniform elements (2) in the longitudinal direction of the two rows (3, 4);
 - c) applying an adhesive to the elements (2) in at least one of the two rows (3, 4);
 - d) bringing at least one of the two rows (3, 4) closer to the other so that the two rows (3, 4) are brought together and thereby bonded to one another by the adhesive.
15
2. Method for making a cellular structure (1) comprising a plurality of elements (2), which method comprises the following steps:
 - a) providing a first plurality of elements (2), which form a first row (3) of elements (2);
 - b) providing a second plurality of elements (2), which form a second row (4) of elements
20 (2), which second row (4) is parallel to the first row (3);
 - c) applying an adhesive to the elements (2) in at least one of the two rows (3, 4);
 - d) bringing at least one of the two rows (3, 4) closer to the other so that the two rows (3, 4) are brought together and thereby bonded to one another by the adhesive so that the two rows thereby form a composite cellular structure (1), which cellular structure is
25 then located in a first position;
 - e) providing a third plurality of elements (2) which form a third row (5) of elements, which third row (5) of elements is parallel to the rows (3, 4) in the composite cellular structure (1);
 - f) moving the cellular structure (1) a certain distance in the longitudinal direction of the
30 first (3) and the second row (4) of elements (2), so that the cellular structure (1) is moved from the first position to a second position;
 - g) applying an adhesive to the elements in at least one of the second row and third row (5), the adhesive being applied either before, after or at the same time as the cellular structure (1) is moved to the second position;

- b) bringing the third row (5) and the cellular structure (1) together with one another so that they are thereby bonded to one another by the adhesive, due to which the third row (5) becomes part of the cellular structure (1).
- 5 3. Method for making a cellular structure (1) comprising a plurality of elements (2), which method comprises the following steps:
- a) providing a first plurality of elements (2), which forms a first row (3) of elements;
- b) providing a second plurality of elements (2), which forms a second row (4) of elements (2);
- 10 c) applying an adhesive to the elements (2) in at least one of the two rows (3, 4);
- d) bringing the elements in at least one of the two rows (3, 4) closer to the other so that the two rows (3, 4) are brought together and thereby bonded to one another by the adhesive to form a cellular structure (1) thereby.
- 15 4. Method according to claim 3, characterized in that the second plurality of elements (2) is provided in that elements (2) intended to form the second plurality of elements are fed in a direction parallel to the first row (3) of elements until a predetermined number of elements (2), which form a second row (4) parallel to the first, are located in a predetermined position, so that the second row (4) is complete and the bringing of the
- 20 elements in at least one of the two rows (3, 4) closer to the other taking place after the second row (4) has reached its predetermined position..
5. Method according to claim 3, characterized in that the second plurality of elements (2) is provided in that elements intended to form the second plurality of elements are fed
- 25 from two opposite directions, which opposite directions are both parallel to the first row of elements, the elements (2) being transported until the elements (2) that are fed in one direction meet elements (2) that have been transported in the opposite direction and together with the elements (2) transported from the other direction form a second row (4) of elements (2), and the bringing of at least one of the two rows (3, 4) closer to
- 30 the other taking place after the second row (4) has been formed.
6. Method according to claim 5, characterized in that the feed from each direction is interrupted after a predetermined number of elements (2) has been transported.

7. Method according to claim 4, characterized in that the feed is interrupted after a predetermined number of elements (2) has been transported.
8. Method according to claim 4, characterized in that all elements (2) have the same shape and that they have a circular-cylindrical shape.
9. Method for making a cellular structure comprising a plurality of circular-cylindrical elements (2), which method comprises the following steps:
 - a) providing a first plurality of uniform circular-cylindrical elements (2), which form a first row (3) of elements (2);
 - b) providing a second plurality of elements (2), which have the same shape as the elements (2) in the first plurality and which form a second row (4) of elements (2), which second row (4) is parallel to the first row (3) but displaced in phase in relation to the first row (3);
 - c) applying an adhesive to the elements (2) in at least one of the two rows (3, 4);
 - d) bringing the elements (2) in at least one of the two rows (3, 4) closer to the other so that the two rows (3, 4) are brought together and thereby bonded to one another by the adhesive to thereby form a composite cellular structure (1).
10. Method according to claim 9, characterized in that a third plurality of elements (2) is provided, the elements (2) in the third plurality of elements (2) having the same shape as the elements (2) in the first and the second plurality and forming a third row (5) of elements, which third row of elements (2) is parallel to the rows (3, 4) in the composite cellular structure (1), that the composite cellular structure (1) is moved a certain distance in the longitudinal direction of the first and second rows (3, 4) of elements from a first position of the composite cellular structure (1) to a second position, that an adhesive is applied to the elements in at least one of the second row (4) and the third row (5), the adhesive being applied either before, after or at the same time as the cellular structure (1) is moved to the second position and in that the third row (5) and the cellular structure (1) following movement of the cellular structure (1) and application of the adhesive are brought together with one another so they are thereby bonded to one another by the adhesive, due to which the third row (5) becomes a part of the composite cellular structure (1).

11. Method according to claim 9, characterized in that the second plurality of elements (2) is provided in that elements (2) intended to form the second plurality of elements are fed from two opposing directions, which opposing directions are both parallel to the first row (3) of elements, the elements (2) being transported until the elements (2) that are fed in one direction meet elements (2) that have been transported in the opposing direction and together with the elements (2) that have been transported from the other direction form a second row (4) of elements, and the bringing of at least one of the two rows (3, 4) closer to the other taking place after the second row (4) has been formed.
12. Method according to claim 11, characterized in that the feed from each direction is interrupted after a predetermined number of elements (2) has been transported and that the second row (4) and the first row (3) are brought together with one another after the feed has been interrupted.
13. Method according to claim 12, characterized in that the bringing together of the elements (2) in the first and the second row (3, 4) of elements (2) takes place in that the elements in the second row (4) are conveyed simultaneously towards the first row (3) so that the whole of the second row (4) is conveyed towards the first row (3) as a coherent unit.
14. Method according to claim 13, characterized in that, during feeding of the circular-cylindrical elements (2), the elements are allowed in both feed directions to pass a detector (6) linked to a control unit (7) and it is recognized in this way how many circular-cylindrical elements (2) pass the detector (6) and that after a predetermined number of elements (2) has passed, the logic unit (7) emits a signal that the feed is to be interrupted.
15. Method according to claim 9, characterized in that adhesive is applied to the elements (2) in a row in that a carriage (15) provided with at least one sensor (16) and a nozzle (13) connected to a source (14) of adhesive is guided along the row at a predetermined speed, the sensor (16) being placed at a distance from the nozzle (13) and detecting the presence or absence of an element and emitting a signal to a logic unit (7) when the presence of an element (2) is detected, and the logic unit (7), starting out from the known speed and the distance between the nozzle (13) and the sensor (16) of the

carriage (15), calculates the time that remains until the nozzle (13) is located in a certain position in relation to an element detected by the sensor (16) and sends a pulse to activate the nozzle (13) when the time calculated has elapsed.

- 5 16. Machine for making a cellular structure (1) comprising a plurality of elements, which machine comprises:
- a) a guide (8) with straight inner walls (9) that form a channel (10) in which a plurality of uniform elements (2) can be transported;
 - b) drives (11) disposed to act on elements placed in the channel (10) to convey these in a first direction, so that a coherent row of elements can be conveyed forwards in the channel (10);
 - c) a carrier (12) arranged in connection with the channel (10), which carrier (12) has an extension that is principally parallel to the first direction and which carrier (12) is also movable in a second direction principally perpendicular to the first direction, so that the carrier (12) can move in the second direction and thereby take with it a coherent row of elements that have been transported in the channel (10), so that the row is carried forward to an end position for the movement of the carrier (12) in the second direction;
 - d) at least one nozzle (13) connected to a source (14) of adhesive and disposed to be movable in a direction parallel to the first direction, which nozzle (13) is either disposed to apply adhesive to a row of elements (2) that has just been conveyed to the end position or to apply adhesive to a row of elements before these have begun to be conveyed towards the end position of the carrier (12).
- 25 17. Machine for making a cellular structure (1) comprising a plurality of elements (2), which machine comprises:
- a) a guide (8) with inner walls (9) that form a channel (10) in which a plurality of uniform elements can be transported;
 - b) a drive (11) disposed to act on elements placed in the channel (10) to convey these forwards in the channel (10);
 - c) at least one sensor (6) connected to the channel (10) and disposed to detect the elements transported in the channel and which sensor (6) is coupled to the drive (11) to interrupt the transportation of elements when a predetermined number of elements has passed the sensor (6);
- 30

- d) a carrier (12) arranged in connection with the channel (10), which carrier (12) is movable, so that the carrier (12) can take with it elements that have been transported in the channel (10), so that elements (2) transported in the channel (10) can be conveyed to an end position for the movement of the carrier (12);
- 5 e) at least one nozzle (13) connected to a source (14) of adhesive and disposed to be movable so that the nozzle (13) can move along a coherent group of elements and apply adhesive to these.
- 10 18. Machine according to claim 17, characterized in that the guide (8) is a straight guide in which a coherent row of elements can be transported in a first direction by the drive (11) and that the carrier (12) has an extension that is principally parallel to the first direction and that the carrier (12) is movable in a second direction that is principally perpendicular to the first direction, so that the carrier (12) can move in the second direction and thereby take with it a coherent row of elements that have been
- 15 transported in the channel (10) so that the row is conveyed forwards to an end position for the movement of the carrier (12) in the second direction.
- 20 19. Machine according to claim 18, characterized in that the machine comprises a table (17) for receiving a coherent row of elements, which table (17) has a flat working surface on which received elements (2) can slide and the carrier (12) being arranged such in relation to the table (17) that the movement of the carrier (12) forwards to the end position for its movement in the second direction can convey elements from the channel (10) to the table (17) for delivery onto the working surface of the table (17).
- 25 20. Machine according to claim 19, characterized in that the table (17) is movable in a direction perpendicular to the direction of movement of the carrier (12) and parallel to the first direction.
- 30 21. Machine according to claim 20, characterized in that a plate or beam (18) is arranged in connection with the table (17), which plate or beam (18) is movable in a direction to and from the working surface of the table (17).
22. Machine according to claim 19, characterized in that the machine has a stand (19) on which a carriage (15) is arranged movably in connection with the working surface of

the table (17) and on which carriage (15) the nozzle (13) is arranged so that the nozzle (13) can be guided along a row of elements standing on the working surface of the table (17) and the carriage (15) being provided with at least one sensor (16) that can detect the presence of an element placed on the table (17) and which sensor (16) is placed at a distance from the nozzle (13) in the direction of movement of the carriage (15).

23. Machine according to claim 22, characterized in that the carriage (15) can be driven at a predetermined speed and that the machine also comprises a logic unit (7) that knows the predetermined speed and the distance between the sensor (16) and the nozzle (13) of the carriage (15) and the logic unit (7) also being connected to the sensor (16) of the carriage (15), so that during movement of the carriage (15) the logic unit (7) can calculate the time that remains before the nozzle (13) is located in a certain position in relation to an element (2) detected by the sensor (16).
24. Machine according to claim 17, characterized in that the channel (10) is disposed to be fed from two different directions.
25. Machine according to claim 24, characterized in that the guide (8) is a straight guide that comprises two fixed parts (20) and a movable part (21), which movable part (21) of the guide (8) is disposed to be able to move in the vertical direction together with the carrier (12) from a first position, in which the movable guide part (8) is located in a plane separate from the working surface of the table (17), to a second position in which at least a part of the movable guide part (8) is located on a level with the working surface of the table (17).
26. Machine according to claim 25, characterized in that the movable guide part (21) comprises a support (22) on which elements for the cellular structure can be placed and which support (22) forms a floor in the channel (10) and the support (22) being adjustable in the vertical direction so that elements of different height can be placed in the correct position in relation to the carrier (12).

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Fig. 1

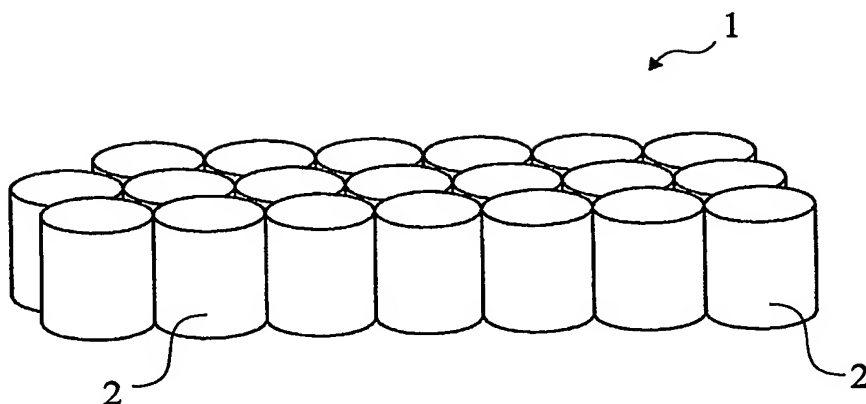


Fig. 2

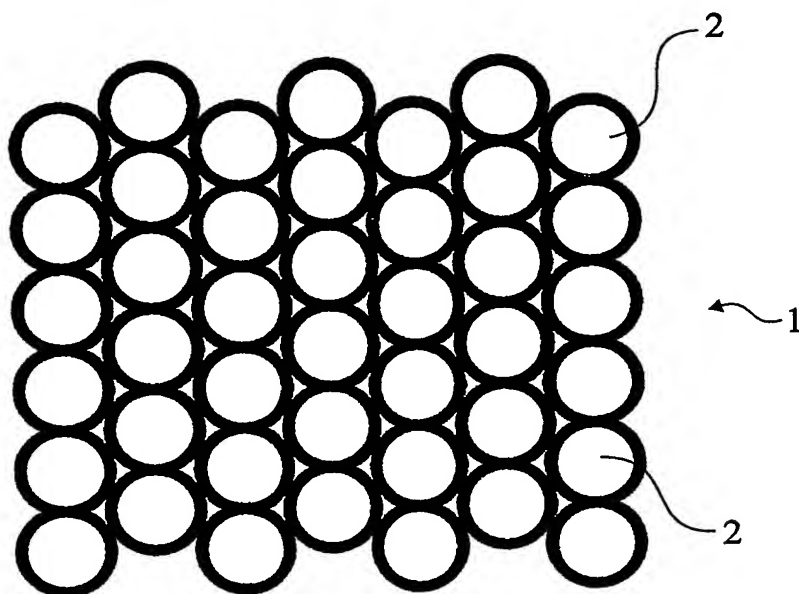
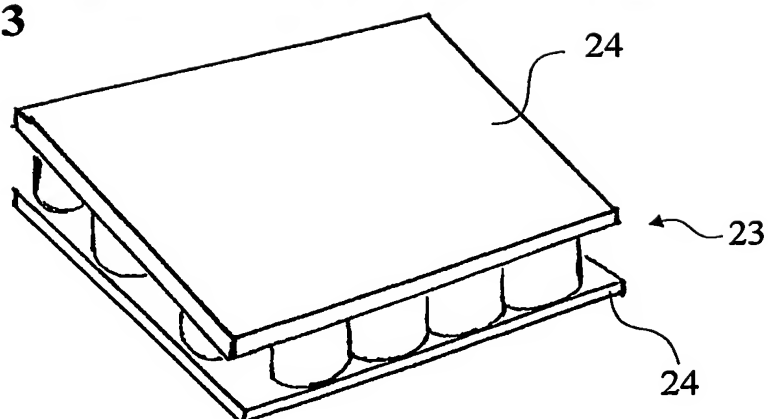
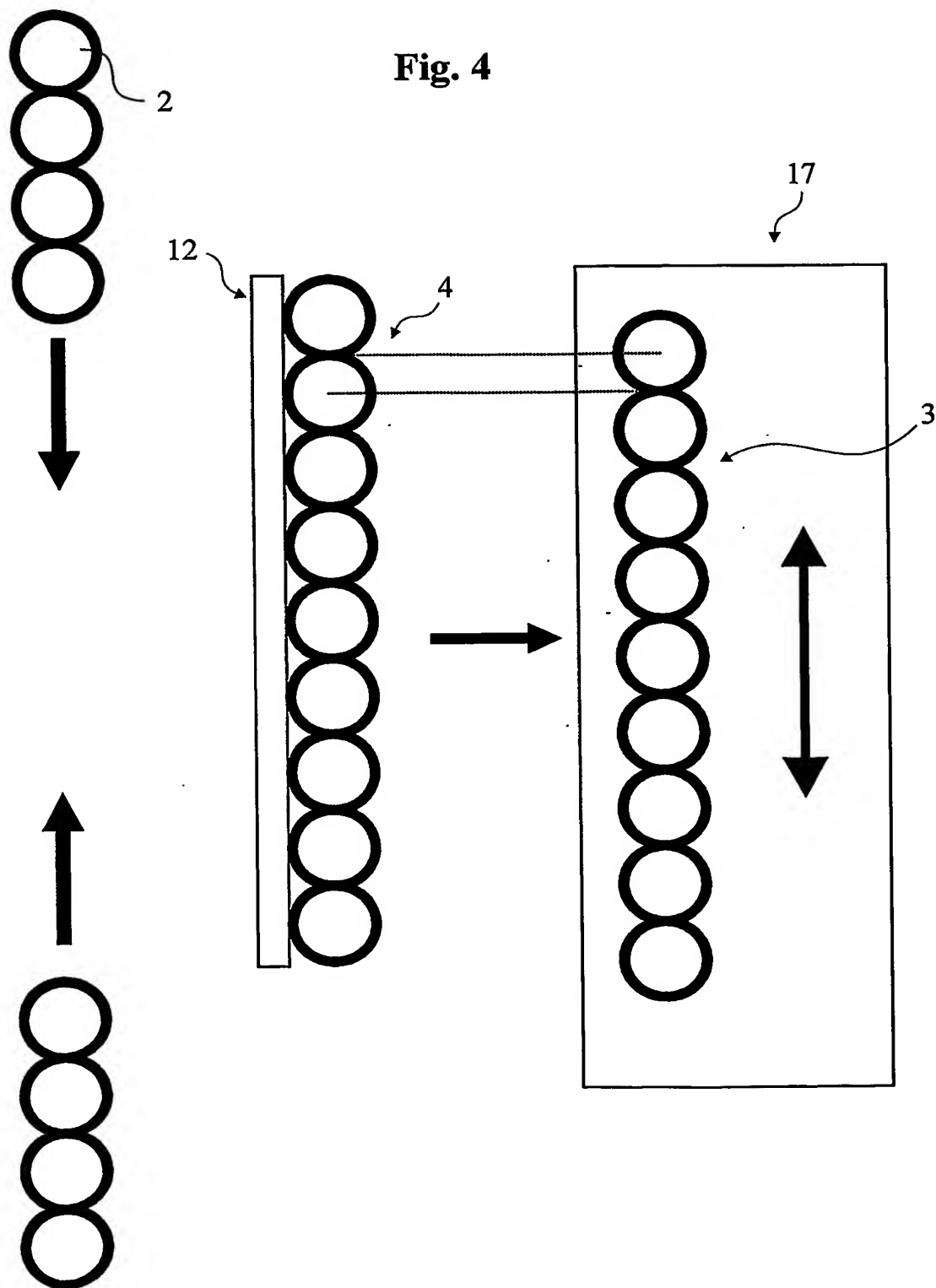


Fig. 3

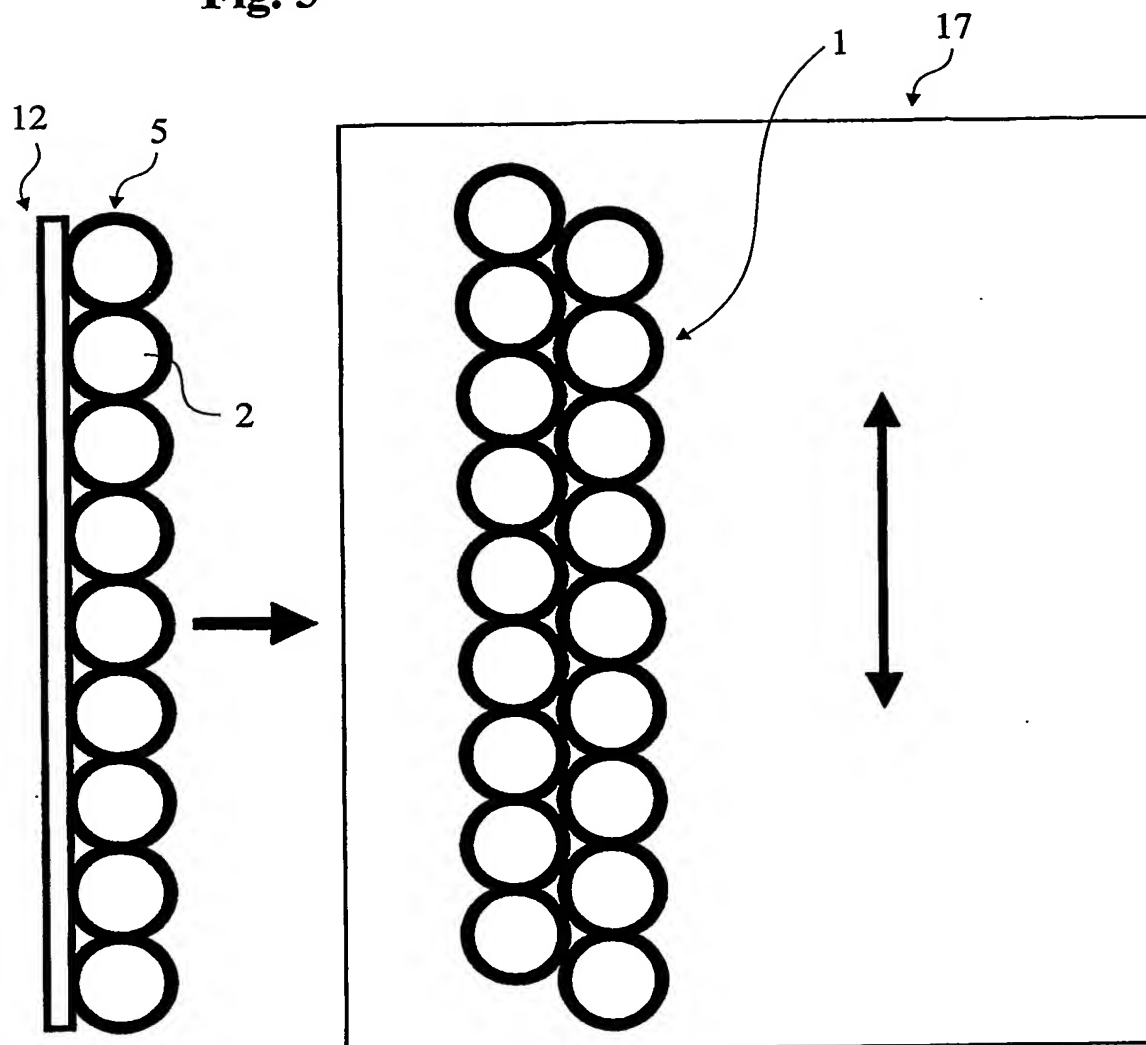


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Fig. 4

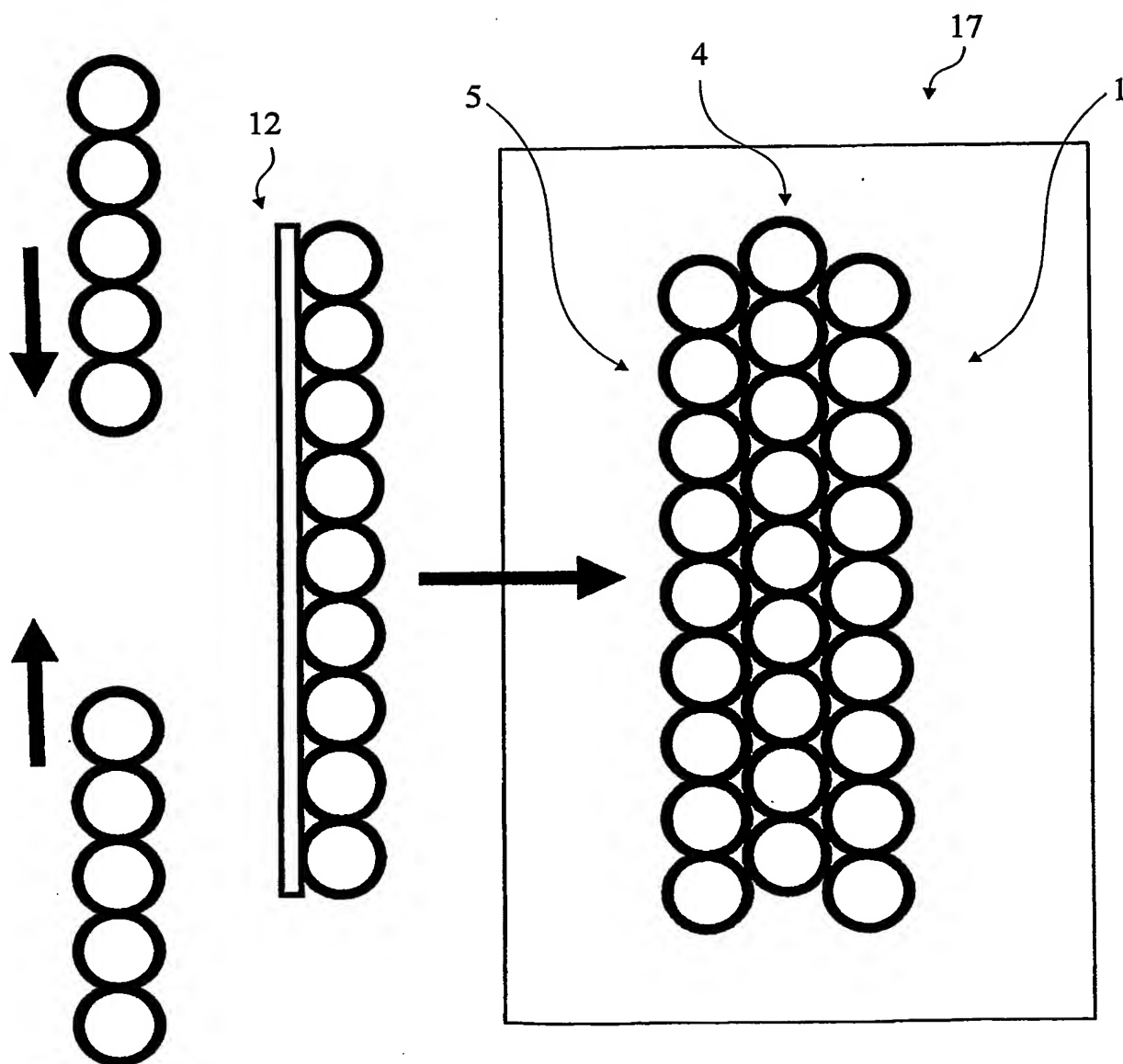


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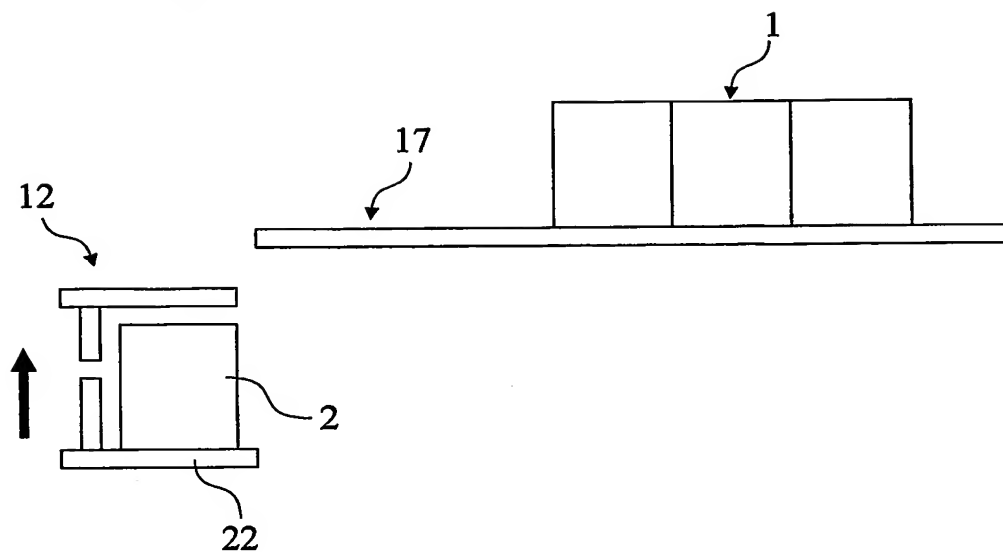
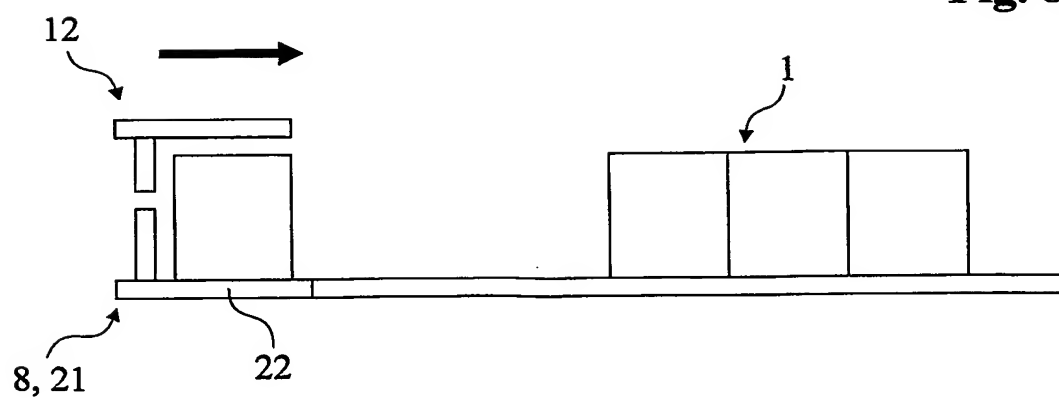
Fig. 5

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Fig. 6



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Fig. 7**Fig. 8**

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Fig. 9

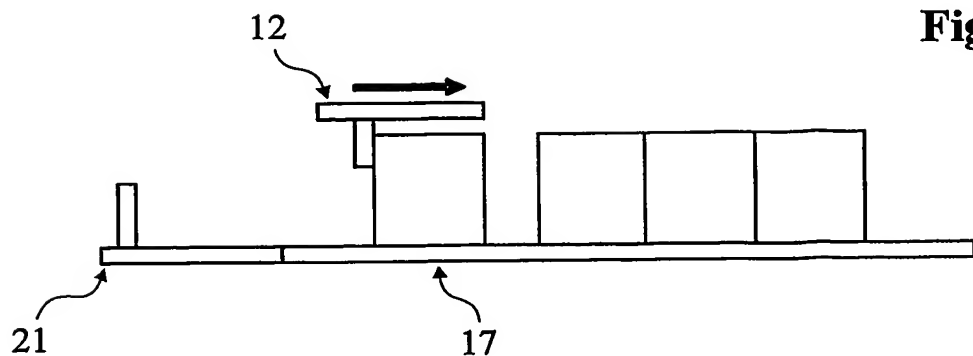


Fig. 10

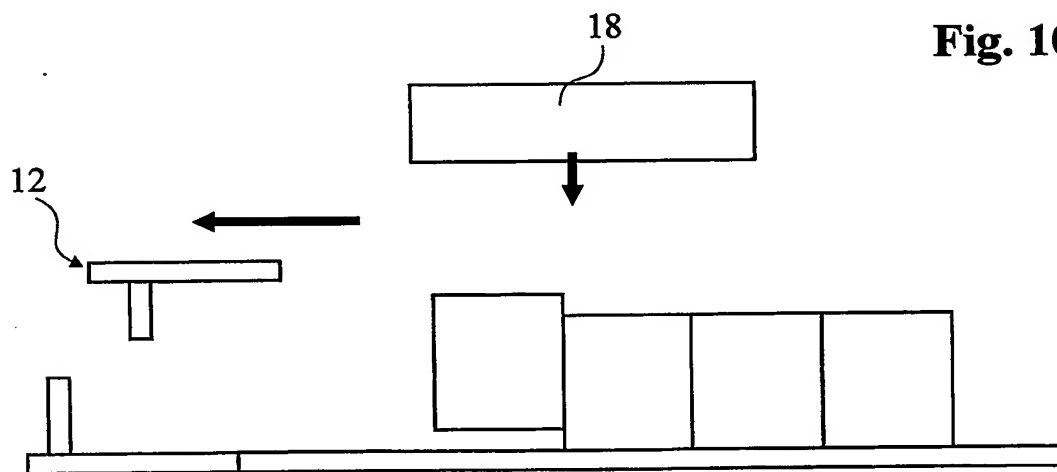
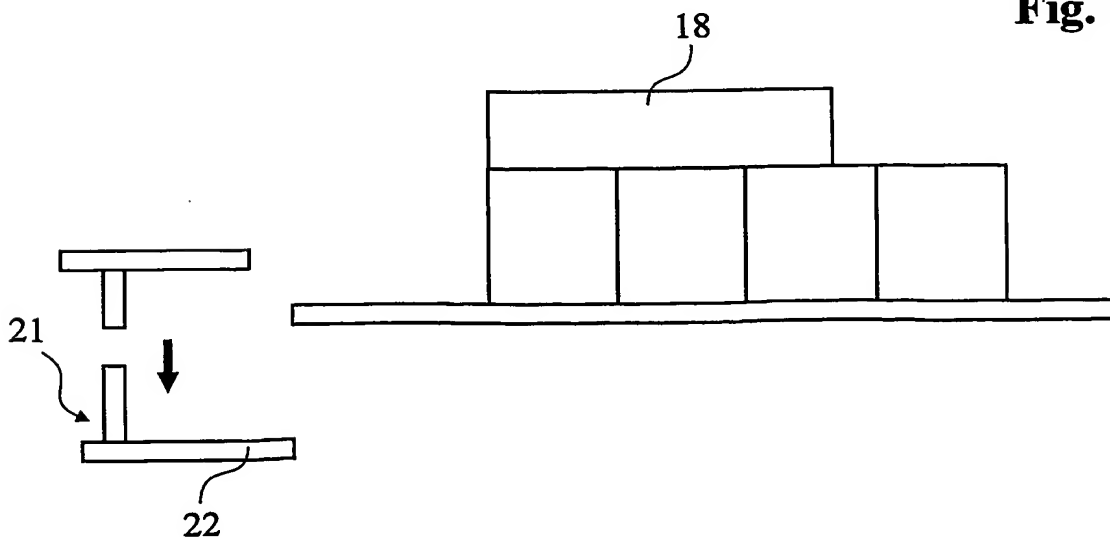


Fig. 11



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Fig. 12a

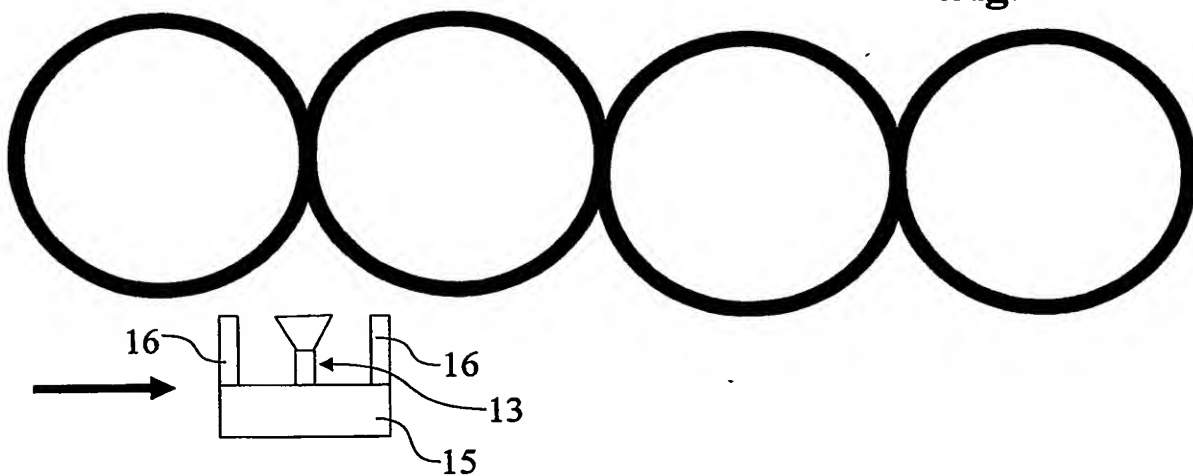
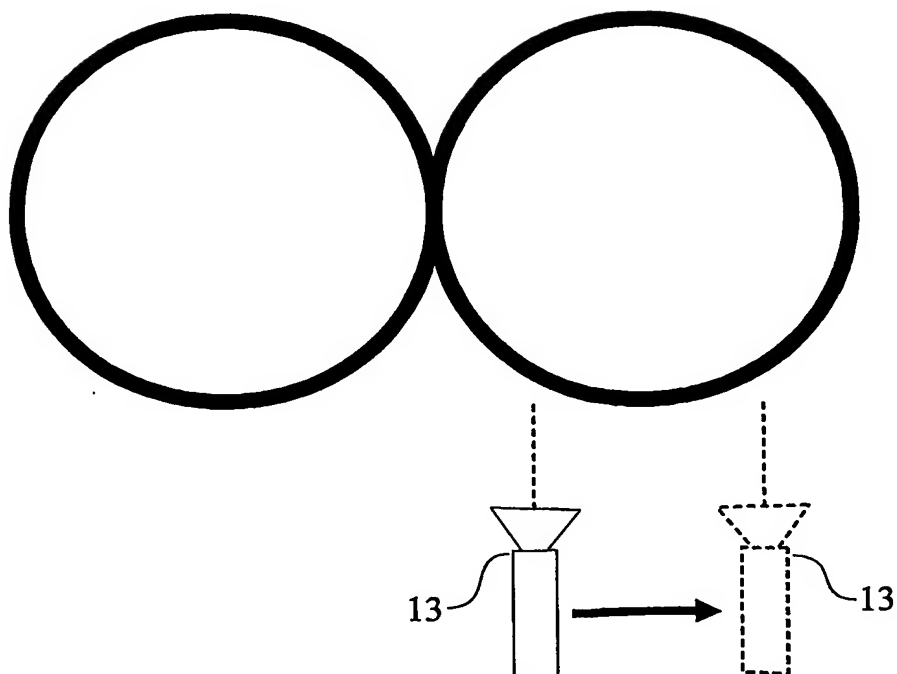


Fig. 12b



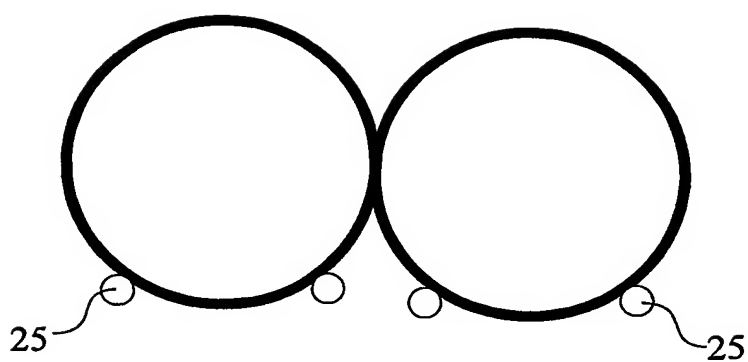
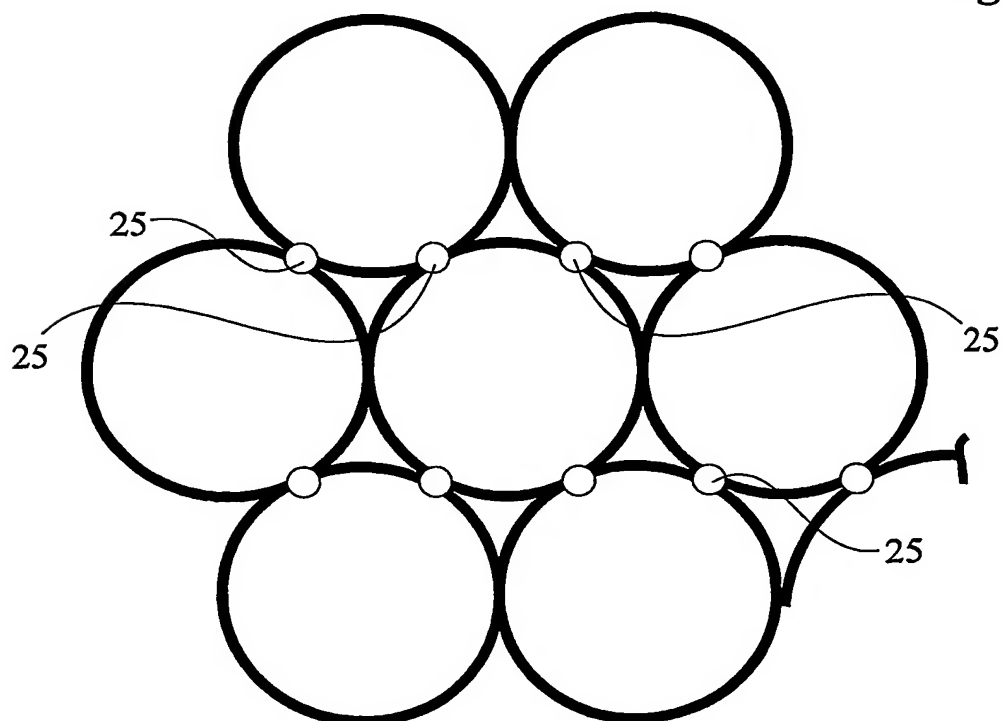
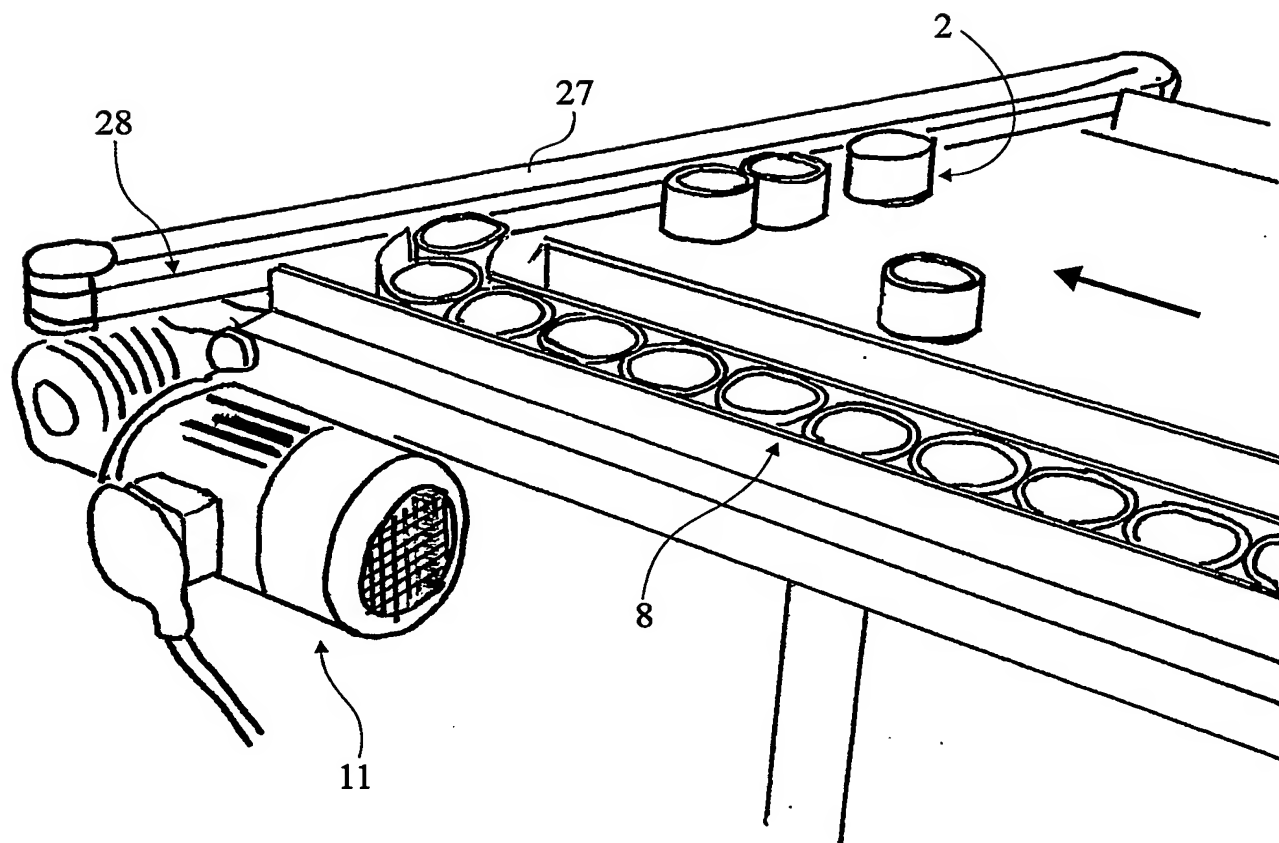


Fig. 13



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Fig. 14



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Fig. 15

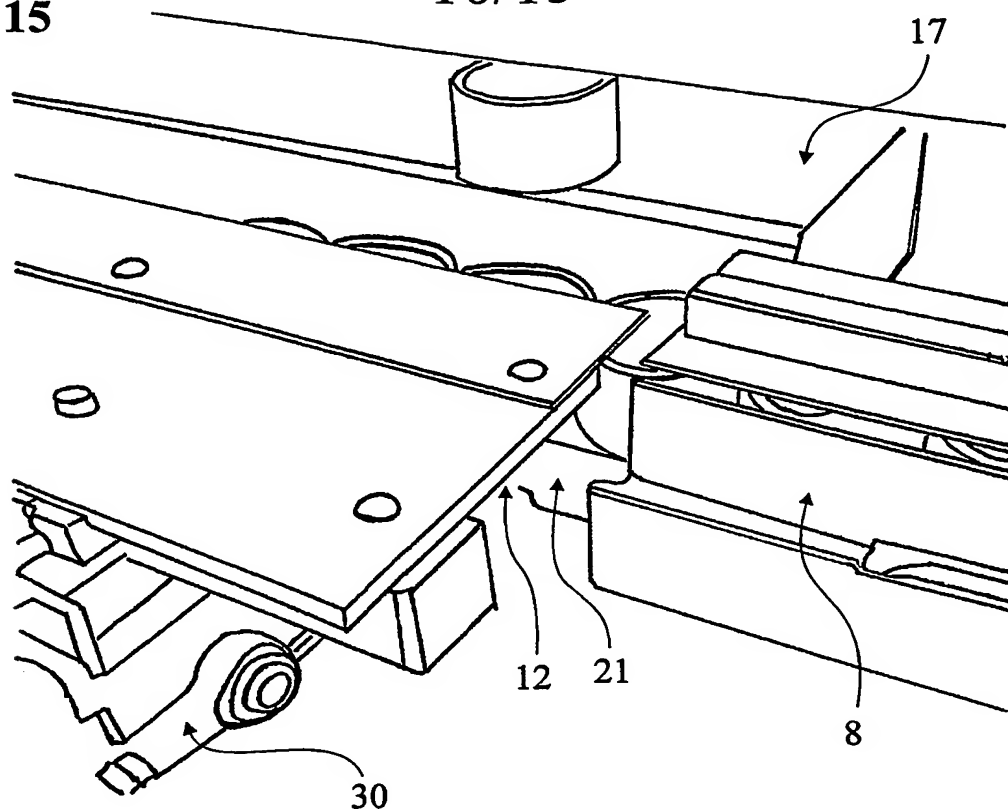
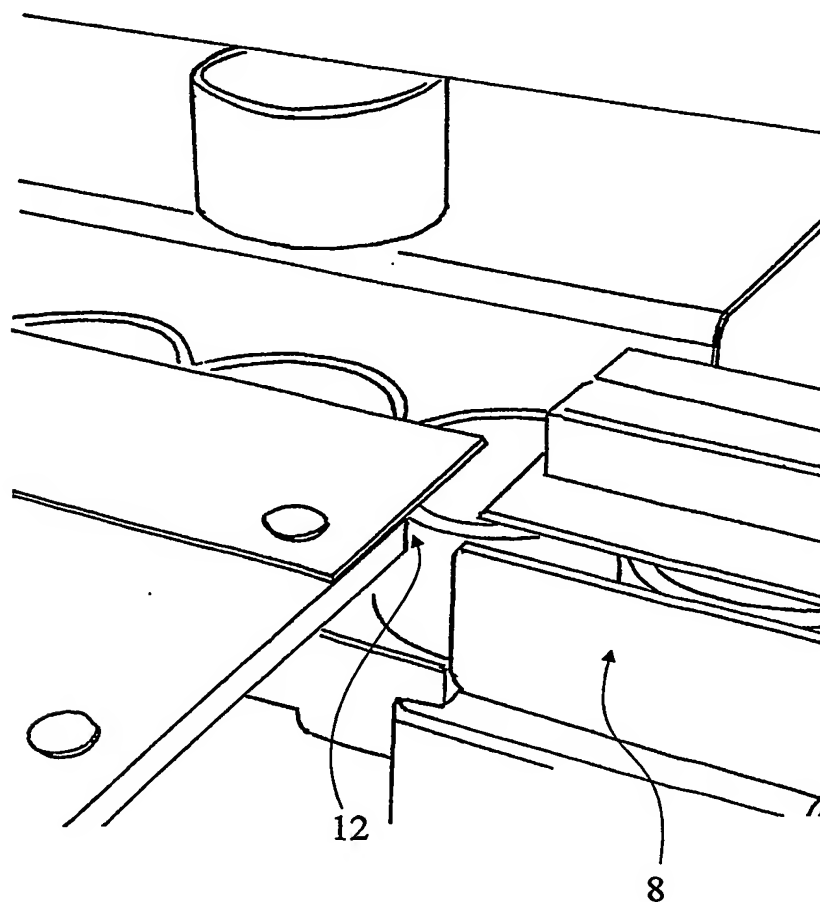
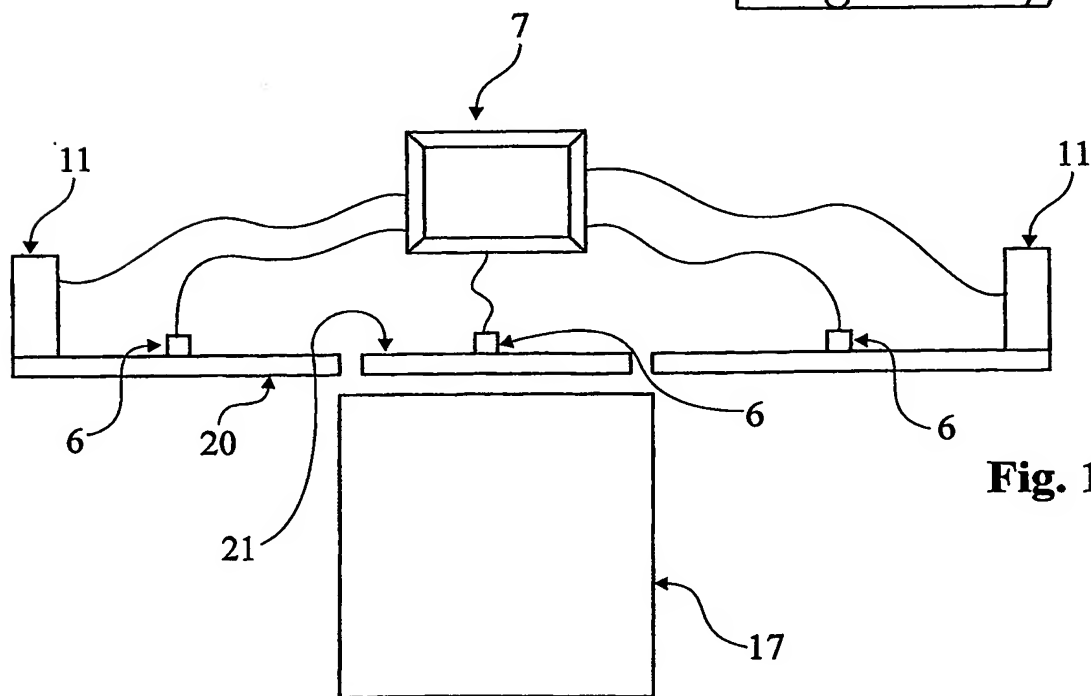
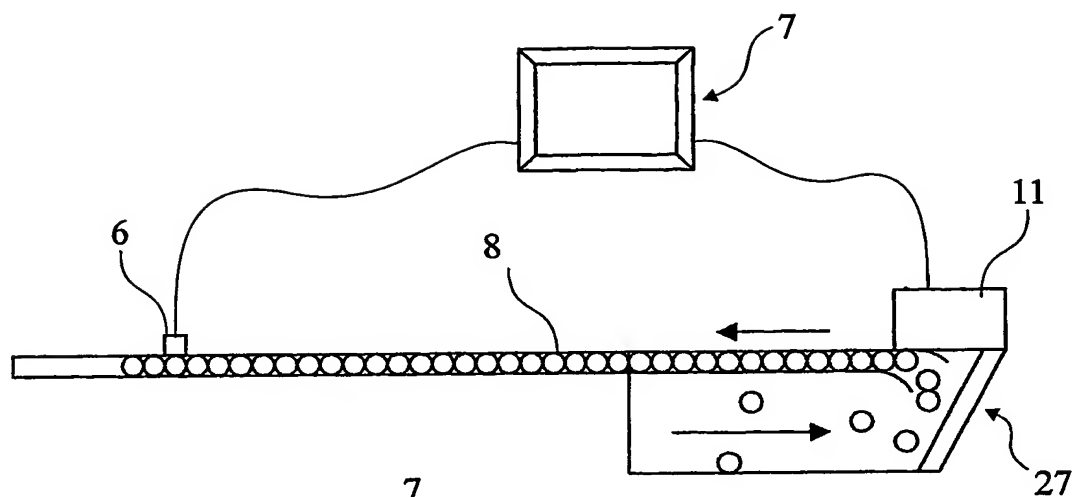


Fig. 16



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Fig. 17**Fig. 18**

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Fig. 19

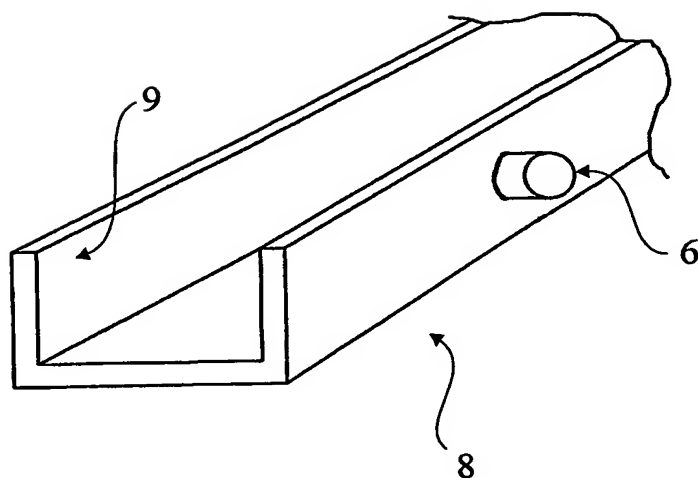
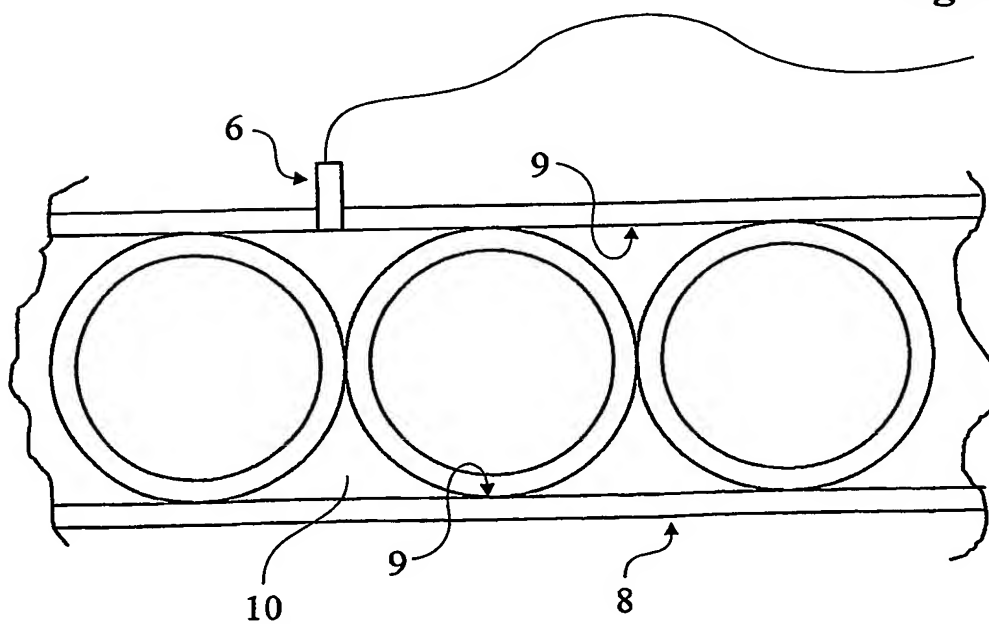
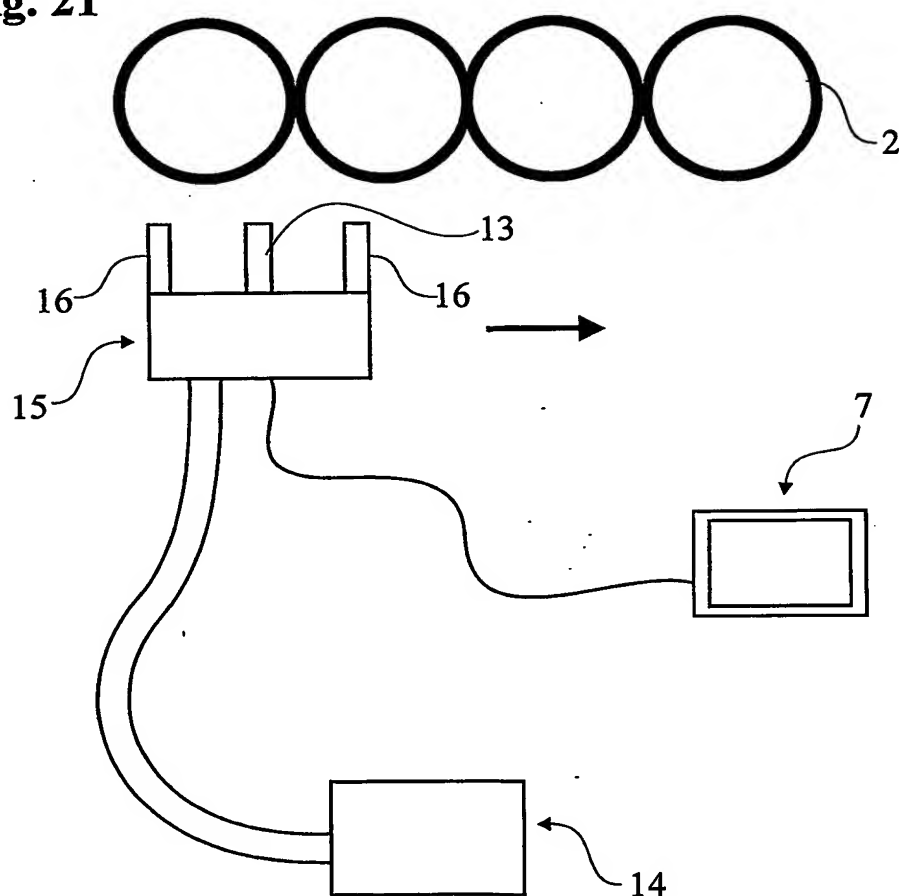


Fig. 20



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Fig. 21

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Fig. 22

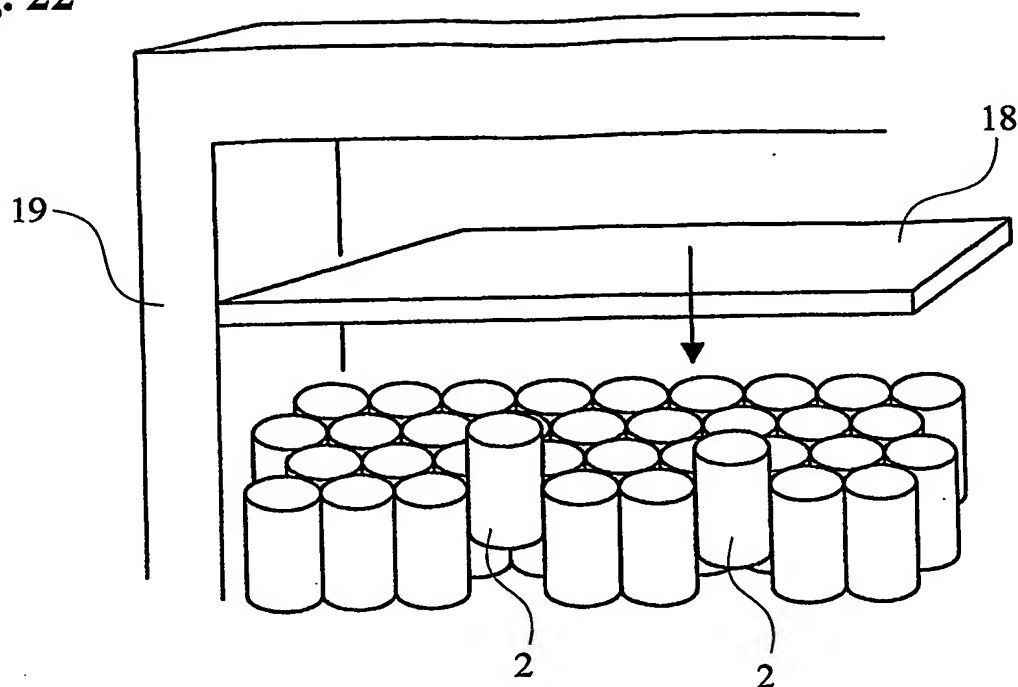
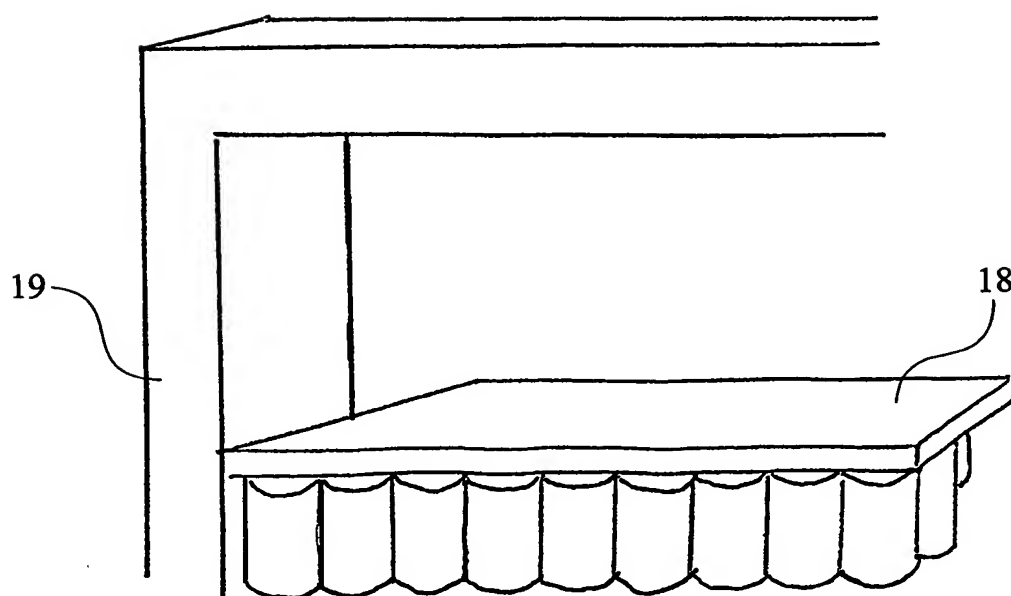
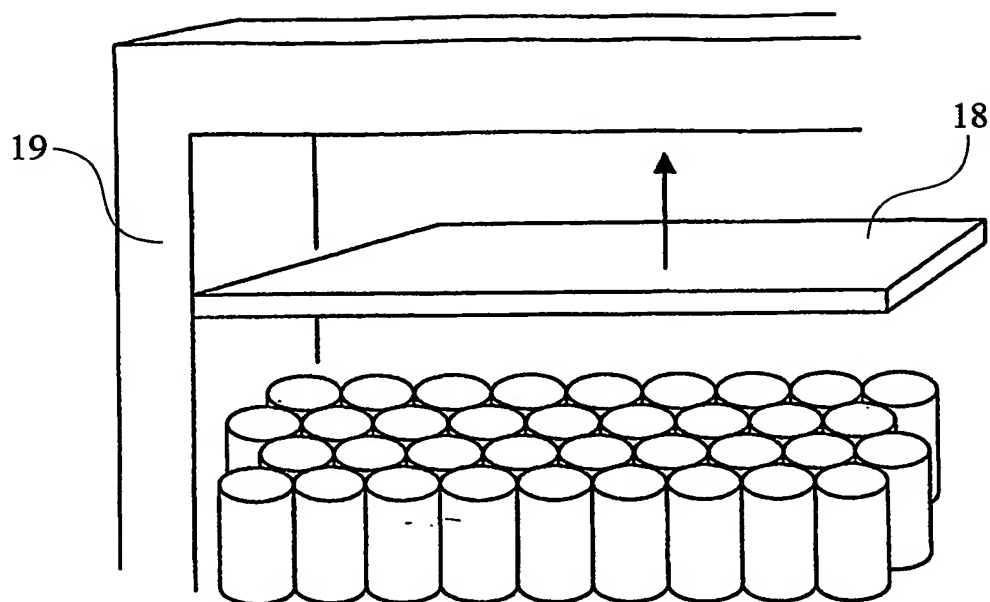
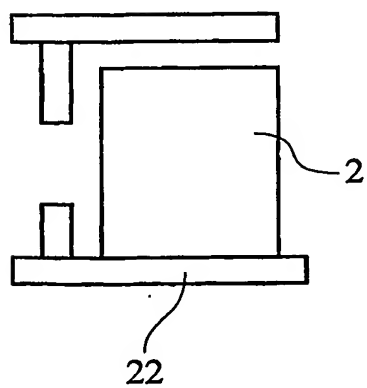
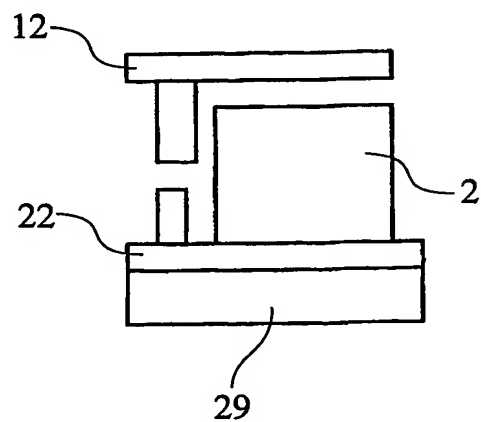


Fig. 23



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Fig. 24**Fig. 25a****Fig. 25b**

INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE 03/01121

A. CLASSIFICATION OF SUBJECT MATTER

IPC7: B32B 3/12, B32B 3/20, E04C 2/36

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC7: B32B, E04C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-INTERNAL, WPI DATA

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 3773584 A (HANS-JOACHIM DIETZSCH ET AL), 20 November 1973 (20.11.73), figures 1,4-6	3
Y		1,4,7-9
A		2,5,6,10-26
	--	
Y	US 6119344 A (CALVIN L. COURT ET AL), 19 Sept 2000 (19.09.00), figures 7,8	1,9
A		2-8,10-26
	--	

☒ Further documents are listed in the continuation of Box C.☒ See patent family annex.

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Date of the actual completion of the international search

24 Sept 2003

Date of mailing of the international search report

26-09-2003

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INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE 03/01121

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 6199342 B1 (CALVIN L. DOURT ET AL), 13 March 2001 (13.03.01), figure 7	4,7,8
A	--	1-3,5,6,9-26
A	EP 0338461 A2 (WILLHELMI WERKE GMBH & CO.KG), 25 October 1989 (25.10.89), figure 1, abstract	1-26
A	--	
A	US 2477852 A (C.E. BACON), 2 August 1949 (02.08.49), figure 1	1-26
A	--	
A	US 5738922 A (TOMOYUKI KOBAYASHI ET AL), 14 April 1998 (14.04.98), figures 1-13	1-26
A	--	
A	WO 9734063 A1 (EUROCON OY), 18 Sept 1997 (18.09.97), figures 1-3, abstract	1-26
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INTERNATIONAL SEARCH REPORT

Internauonal application No.

PCT/SE 03/01121

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US	6199342	B1	13/03/01	AU	2599299 A	30/08/99
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